

Split

Work Order ID 50004A -1

July 2, 2009 3:37:49 PM



Page 1

Item ID: D3011-1

Revision ID: A

Item Name: Rappel

Start Date: 07/06/2009 Start Qty: 10.00

Required Date: 07/15/2009 Req'd Qty: 10.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID      Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3011

Rev A

100



Bandsaw

Jeuspa Bandsaw

BAND SAW

Memo

Cut Blanks: 26.57"

0.00

0.00

SP 09/07/17

4

110



HAAS I

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Ensure Batch Number programmed matches this W/O

Machine as per folio FA129

0.00

0.00

SP 09/07/17

4

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

SP 09/07/17

4

Work Order ID 50004

July 2, 2009 3:37:49 PM



Page 2

Item ID: D3011-1

Revision ID: A

Item Name: Rappel

Start Date: 07/06/2009 Start Qty: 10.00

Required Date: 07/15/2009 Req'd Qty: 10.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

*Jul 09-07-20*

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

*4 09-07-20 (4)*

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

*M 112148*  
START TIME: *1:25*  
OVEN TEMPERATURE: *300°*  
FINISH TIME: *1:55*

*BR 09-07-20 (4)*

Work Order ID 50004

July 2, 2009 3:37:49 PM

Item ID: D3011-1

Revision ID: A

Item Name: Rappel

Start Date: 07/06/2009 Start Qty: 10.00

Required Date: 07/15/2009 Req'd Qty: 10.00

Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Run Start

Stop

Approvals: Process Plan: Date:

Tooling: Date:

QC: Date:

SPC (Y/N): Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

170

Identify as per dwg &amp; Stock Location: GA

0.00



Packaging

Packaging

Memo

0.00

180

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

09/07/21 JF  
MF 09-07-20

# Print

July 2, 2009 3:37:48 PM

Page 1

Work Order ID: 50004



Parent Item: D3011-1RevA

Parent Item Name: Rappel


Comments:

Start Date: 07/06/2009

Required Date: 07/15/2009

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6202RevA  I-Beam Extrusion		Manufactured	No			110	f	36.1000	10.0000			



<u>Warehouse</u>	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse			
	MAT	36.1	
	14742	6.1	
	37669	30	

B 50040

11.000  
49.1

ml 0407/20



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 50009
<b>Description:</b> Rappel Slide Bar		<b>Part Number:</b> D3011-1
<b>Inspection Dwg:</b> D3011-1 <b>Rev:</b> A		<b>Page 1 of 1</b>

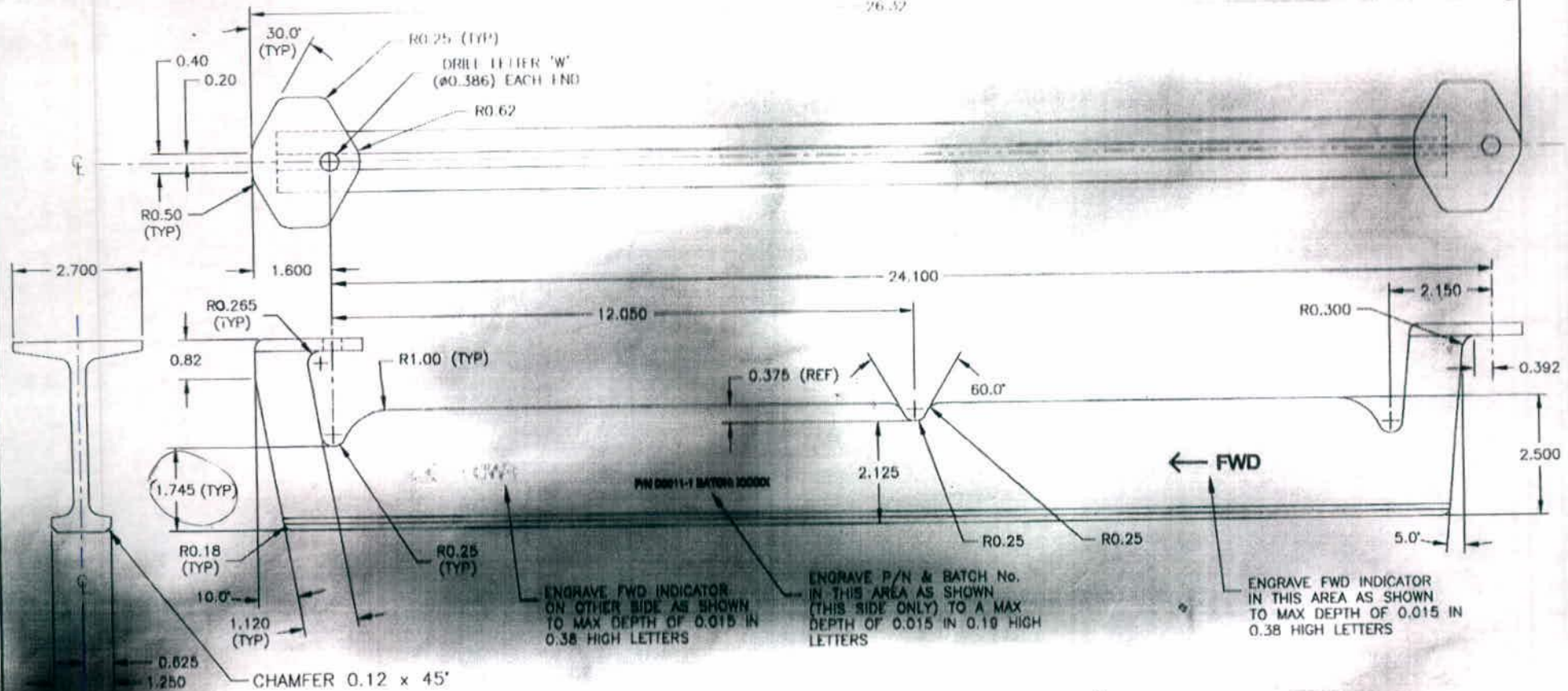
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.700	+/-0.010	2.700	✓			
1.250	+/-0.010	1.254	✓			
0.625	+/-0.010	.625	✓			
0.120 x 45°	+/-0.010 x +/-0.5°	.120 x 45°	✓			
Ø0.386	+0.005/-0.001	Ø.388	✓			
1.600	+/-0.010	1.600	✓			
26.32	+/-0.030	26.32	✓			
R0.50	+/-0.030	R.500	✓			
30°	+/-0.5°	30°	✓			
0.275	+/-0.010					
2.500	+/-0.010	2.494	✓			
5°	+/-0.5°	5°	✓			
24.100	+/-0.010	24.100	✓			
1.125	+/-0.010					
R0.25	+/-0.030	R.250	✓			
0.375	+/-0.010	.376	✓			
1.120	+/-0.010	1.123	✓			
1.745	+/-0.010	1.744	✓			
0.82	+/-0.030	.810	✓			
10°	+/-0.5°	10°	✓			

<b>Measured by:</b> <i>SM</i>	<b>Audited by:</b> <i>[Signature]</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 09/07/19	<b>Date:</b> 09/07/20	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.04	New Issue	KJ/DD <i>[Signature]</i>	<i>[Signature]</i>



RELEASED



MANUFACTURE FROM D6202-027 EXTRUSION  
 BREAK ALL SHARP EDGES 0.010-0.020  
 PREPARE ACID LETCH AND ALODINE PER DART QSI 005 4.1  
 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
 ALL DIMENSIONS ARE IN INCHES

COPYRIGHT © 2001 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL  
 AND IS SUPPLIED ON THE EXPRESS CONDITION  
 THAT IT IS NOT TO BE USED FOR ANY PURPOSE  
 OR COPIED OR COMMUNICATED TO ANY OTHER  
 PERSON WITHOUT WRITTEN PERMISSION FROM  
 DART AEROSPACE LTD.

A	01.03.29	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD. HAMMERSLEY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3011
DATE	01.03.29	TITLE RAPPEL SLIDE BAR
		REV. A SHEET 1 OF 1 SCALE 1:2

#5004.  
 MF  
 09-07-02